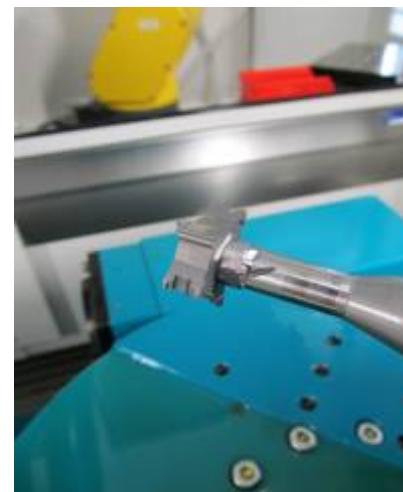


Turning Insert width 10mm

A08-250

The turning insert with 5 cutting edges is probed on all the 5 references sides to assign the corresponding position of the an edge with respect to its reference faces. Using the TTC Pin-Clamping, all process are applicable in one setup: chipbreaker grinding, Profile pre- and finishgrinding.

Programming and Simulation time: 20 Min., Setuptime for good tool: 30 Min. (wheels and clamping device already in use for previous tools)



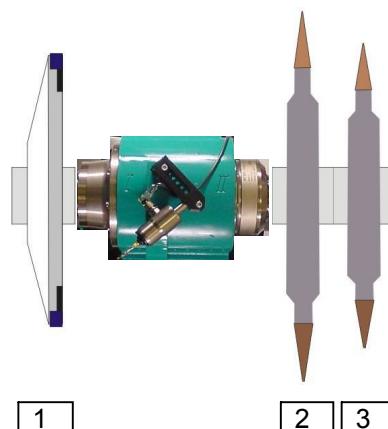
1. Cycletime for Production

Workpiece:	Z5, H15 mm, T 10 mm Material CARBIDE		
Operations	Probe Chipbreaker Pregrind Finishing		
Feed [mm/Min]	2000	100	35
Power [kW]		1	4
Cutting speed [m/s]		22	22
Used wheels		1	2
Grinding time [s]	30	193	300
Total cycle time	11 Min 49		

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	12C9 Ø250 D64
2	14EE1 Ø250 D76V20°
3	14EE1 Ø200 D54V20°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31iA5

Software: Quinto 5

Accessories: TTC

Responsible engineer: OP. 3.7.12

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